

*AC*  
Work Order ID 98216

\*98216\*

Page 1

March-08-13 2:48:34 PM

Item ID:	D3934-041	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:				Stop		*NS2*	
Item Name:	Clip Assembly						
Start Date:	3/08/13	Start Qty:	20.00	*20*	Cust Item ID:		
Required Date:	3/11/13	Req'd Qty:	20.00	*20*	Customer:		
Reference:							
Approvals:	Process Plan: <i>V</i>	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3934	RevA								
100		0.00							
*100*									
Waterjet	Memo								
FLOW CNC Waterjet	1-Cut as per Dwg D3934 Dwg Rev: <i>A</i> Prog Rev: <i>A</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo								
Quality Control									

(DAS  
05  
9-8 13-03-10)

(DAS  
05  
9-8 13-08-10)

Work Order ID 98216

\*98216\*

Page 2

March-08-13 2:48:34 PM

Item ID: D3934-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Clip Assembly

Stop

\*NS2\*

Start Date: 3/08/13 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 3/11/13 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Quality Control

(20)

13-03-13

DAS  
09  
9-89

130

\*130\*

Brake NC

Brake NC

Memo

0.00

20

J3/03/14  
26/3/13

1- C'sink holes as per dwg

2- Bend as per dwg D3934

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Quality Control

Memo

0.00

(20)

13-03-14

DAS  
09  
9-89

141

Install nut plate as per dwg

20X

J3/03/14

142

QC 5 (20) 13-03-14

DAS  
09  
9-89

**Work Order ID 98216**

March-08-13 2:48:34 PM

**\*98216\***

Page 3

Item ID: D3934-041      Accept: \*N900040100\*      Setup Start: \*NS1\*

Revision ID:

Item Name: Clip Assembly      Stop: \*NS2\*

Start Date: 3/08/13      Start Qty: 20.00      \*20\*

Cust Item ID:

Required Date: 3/11/13      Req'd Qty: 20.00      \*20\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start: \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop: \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: ST 073	0.00							20x 88 13-3-14.
	Memo	0.00							
160 <b>*160*</b> QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							13/3/18 JF
	Memo	0.00							

MB-03-15

# Picklist Print

March-08-13 2:48:33 PM

Page 1

Work Order ID: 98216

Parent Item: D3934-041

Parent Item Name: Clip Assembly

Start Date: 3/08/13

Required Date: 3/11/13

Start Qty: 20.00

Required Qty: 20.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			150	sf	287.5001	0.021	0.4421053		13.03.10	
							<u>Location</u>	<u>Loc Qty</u>					
							MAT020	287.500065					
							121380	0.000065					
							122732	32					
							122753	98.8					
							124029	156.7					
MS21075L3 Nutplate		Purchased	No			150	Each	404.0000	1	20		JS 13/03/14	
							<u>Location</u>	<u>Loc Qty</u>					
							GA	384					
							124670	384					
							ST318	20					
							123832	5					
							124551	15					
MS20426AD3-3 Rivet		Purchased	No			100	Each	7,041.0000	2	40		JS 13/03/14	
							<u>Location</u>	<u>Loc Qty</u>					
							GA	65					
							122814	65					
							ST316	699					
							119109	282					
							19099	417					
							ST333	6277					
							121011	69					
							123352	6208					

DART AEROSPACE LTD	Work Order:	9840
Description: Clip Assembly	Part Number:	D3934-1
Inspection Dwg: D3934	Rev: A	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

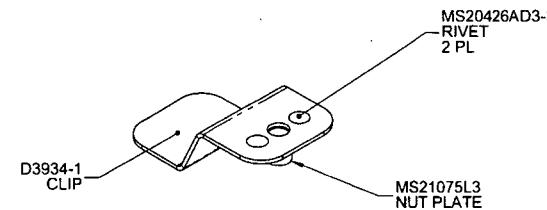
## X First Article      Prototype

15

Measured by:	<u>M.M.</u>	Audited by:	<u>09</u> <u>9-89</u>	Prototype Approval:	N/A
Date:	13.03.10	Date:	13.03.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	MM

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3934-041	CLIP ASSEMBLY
10	1	D3934-1	CLIP
20	1	MS21075L3	NUT PLATE
21	2	MS20426AD3-3	RIVET



D3934-041 CLIP ASSEMBLY

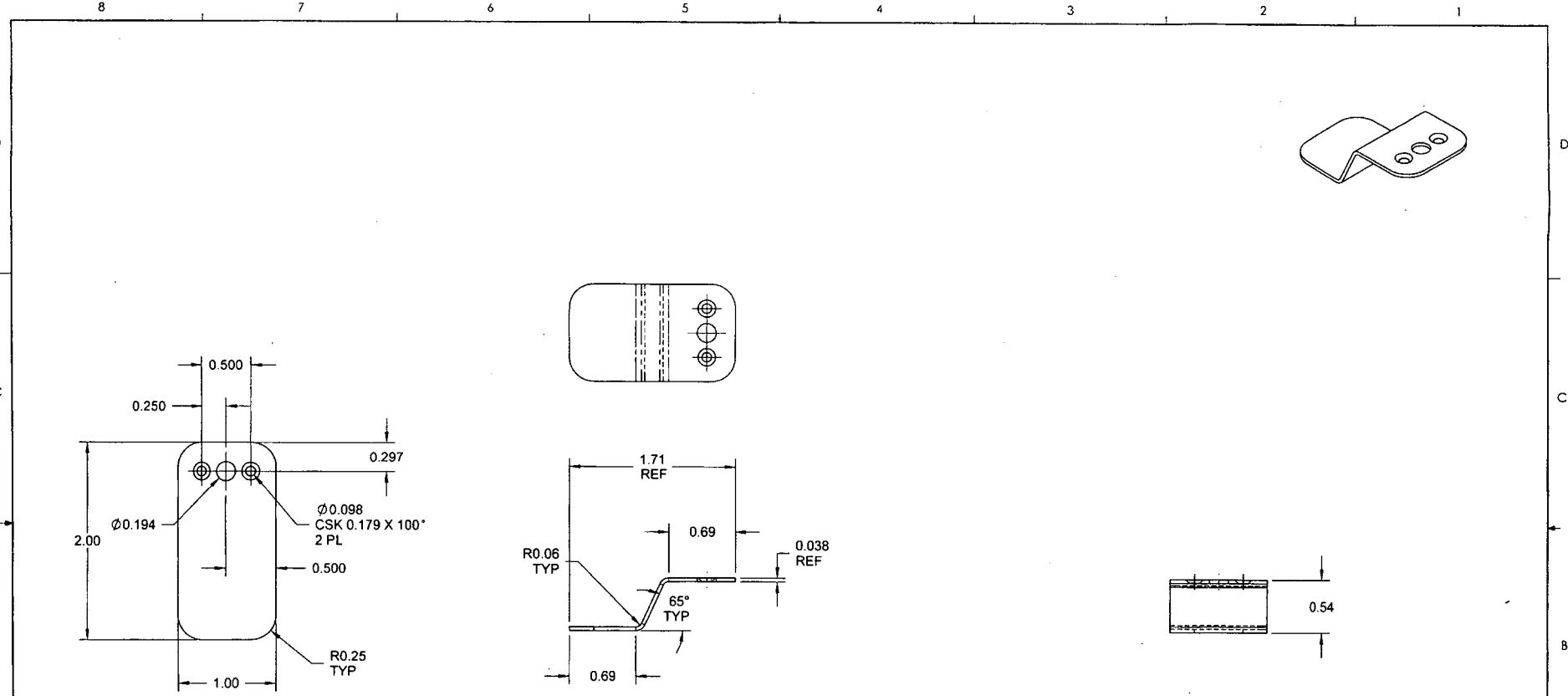
W098216

RELEASED  
09/05/2010

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3934-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	PH	09.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	M1	DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA
DRAWN	PER	DRAWING NO.	REV. A
CHECKED	M	D3934	SHEET 1 OF 2
MFG. APPR.	Z	TITLE	SCALE
APPROVED	M	CLIP ASSEMBLY	NTS
DE APPR.	M	DATE	09.04.16

COPYRIGHT © 2009 BY DART AEROSPACE LTD.  
THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD., AND IS SUPPLIED ON THE CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**D3934-1F FLAT PATTERN**

**D3934-1 CLIP**  
(MAKE FROM D3934-1F)

**RELEASED**  
*09/05/05 M*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
20 GAUGE (0.038 THICK)  
REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>P&amp;J</i>	<b>DART AEROSPACE LTD</b>						
DRAWN	<i>P&amp;J</i>	HAWKESBURY, ONTARIO, CANADA						
CHECKED	<i>A</i>	DRAWING NO.						
MFG. APPR.	<i>EZ</i>	REV. A						
APPROVED	<i>MW</i>	D3934						
DE APPR.	<i>MW</i>	SHEET 2 OF 2						
DATE	09.04.16							
CLIP ASSEMBLY								
COPYRIGHT © 2009 BY DART AEROSPACE LTD								
THIS DOCUMENT IS PROPRIETARY CONFIDENTIAL AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN FOR WHICH IT WAS PROVIDED OR FOR USE BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD								